

Date: Thursday, 2/9/2006 1:17:11 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACK FRAME ASSEMBLY				
Job Number	: 25791							
Estimate Number	: 11129							
P.O. Number	: N/A			Part Number	: D3017041			
This Issue	: 2/9/2006		S.O. No.	: N/A				
Prsht Rev.	: NC			Drawing Number	: D3017 REV A			
First Issue	: N/A		Type	: LARGE FAB ASSY				
Previous Run	: N/A		Material	: N/A				
Written By	: SEE COMMENT BELOW			Due Date	: 2/25/2006			
Checked & Approved By	: <u>JK</u> 06.02.09			Qty:	1	Um: Each		
Comment	: Est. A 01.09.19 New issue EC							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W	
		Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: <u>M11642</u>	<u>JK</u> 06/02/10
2.0	M4130NS049	4130 Sheet .049 wall	
		Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s) 4130 Sheet .049 wall Cut:- AISI 4130N sheet, 18 gauge (0.050 thick) Batch: <u>M16449</u>	<u>JK</u> 06/02/10
3.0	D30177	Lug	
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Lug Pick: Qty Part Number Description Batch 3 D3017-7 Lug <u>B22411</u>	<u>JK</u> 06/02/10
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Cut end caps as per Dwg D3017

3-Weld as per Dwg D3017 using Welding Jig Dt8598

A/R Steel Rod Batch: M9430JK 06/02/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/02/21	H.1	Install D3023-1 to 3017-041 40 MS 20600 AD 4W2 Rivet M4747 6 MS 20600 AD 4W3 Rivet M18071 Back Panel D3023-1 B25797	SB	06/02/21	1	<i>BS</i> <i>QI</i>	<i>16-02-21</i>
		Inspect QCS <i>✓</i> 06-02-21					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes *No* DQA: *✓* Date: 06/02/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:17:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 25791

Part Number: D3017041

Job Number:



Seq. #: Machine Or Operation:

Description :

4-Drill D3017-041 Using DT8621

AD 06/02/13

5-Deburr

5.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-02-13

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/02/28

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G1

SB 06/02/28

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AD 06/02/28

Job Completion



U 06-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

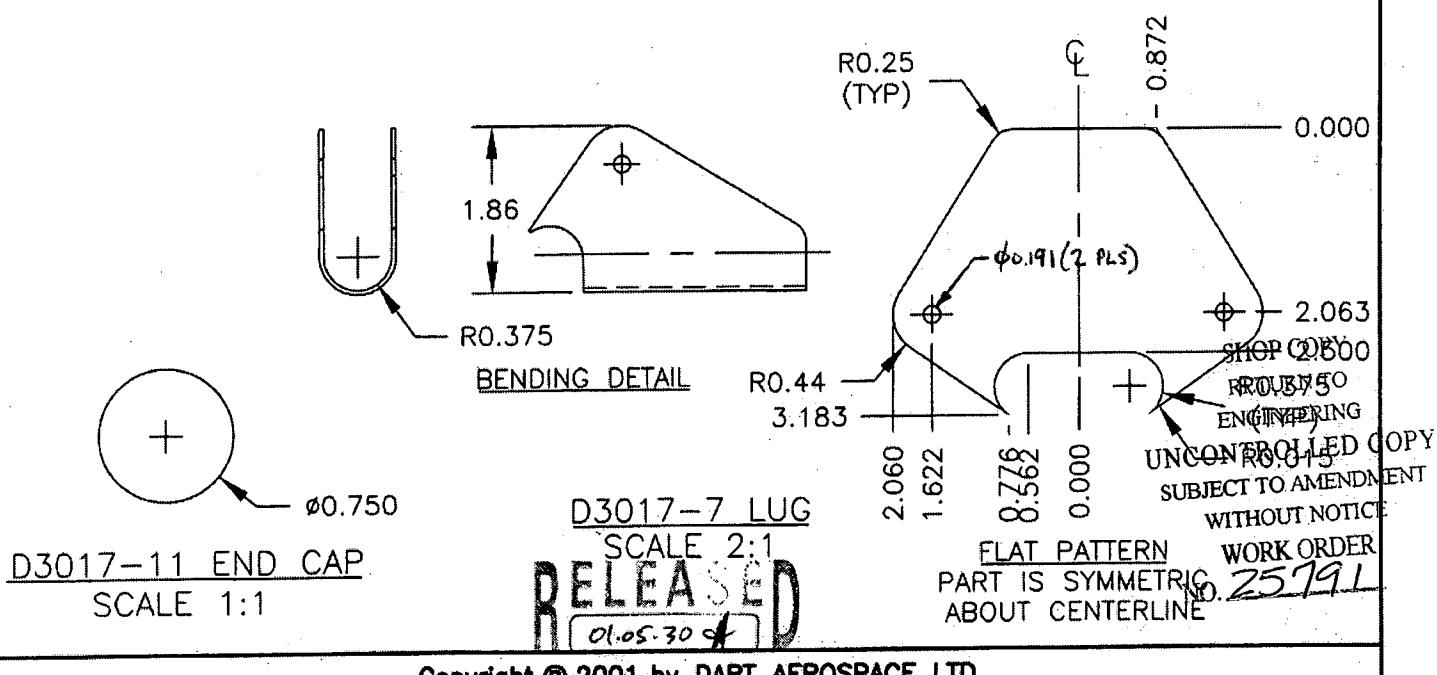
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 2
		D3017	
DATE		TITLE	SCALE
01.05.18		BACK FRAME ASSEMBLY	1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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